

Work Order ID 61525

August 30, 2010 10:12:07 AM



Page 1

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 30/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/09/2010 Req'd Qty: 2.00

Customer:

Reference:

10-08-30

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

M.A 10/09/13

2

0

Jeaspa Bandsaw

Cut blanks 4.425"

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

M.A 10/09/13

2

0

HAAS CNC vertical machine #1

1-Machine per folio FA940
FOLIO REV: *B*
DWG REV: *B*
2-Deburr any rough edges

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

M.A 10/09/13

2

0

Quality Control

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>cm 10/09/13</i>		<i>2</i>	<i>0</i>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>BR 10-9-14</i>		<i>2</i>			
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115291</i> Memo START TIME: <i>2:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>2:30</i>	0.00 0.00		<i>BR 10-9-21</i>		<i>2</i>			

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Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 30/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 08/09/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 25

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

2 0

10/9/22 2

10/09/23

MF
10-9-22

Picklist Print

August 30, 2010 10:12:07 AM

Page 1

Work Order ID: 61525



Parent Item: D2857-1



Parent Item Name: Hinge Bracket

Start Date: 30/08/2010

Required Date: 08/09/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 00.06.22 Removed P/O for powder coat EC
 IPP D 06.05.01 Added level 8 EC IPP Rev:E
 10.06.10 remove seq150 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	30.3467	0.37	0.778947			



6061-T6 Bar 2.00 x 1.25

Location	Loc Qty	Loc Code
MAT	30.3467	
114507 114407	18.3467	
114899	12	

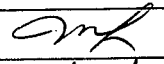
0.7789 ft A.A 10/09/13

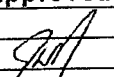

DART AEROSPACE LTD		Work Order: 61525
Description: Hinge Bracket		Part Number: D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

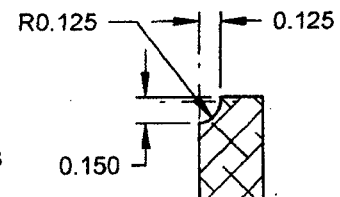
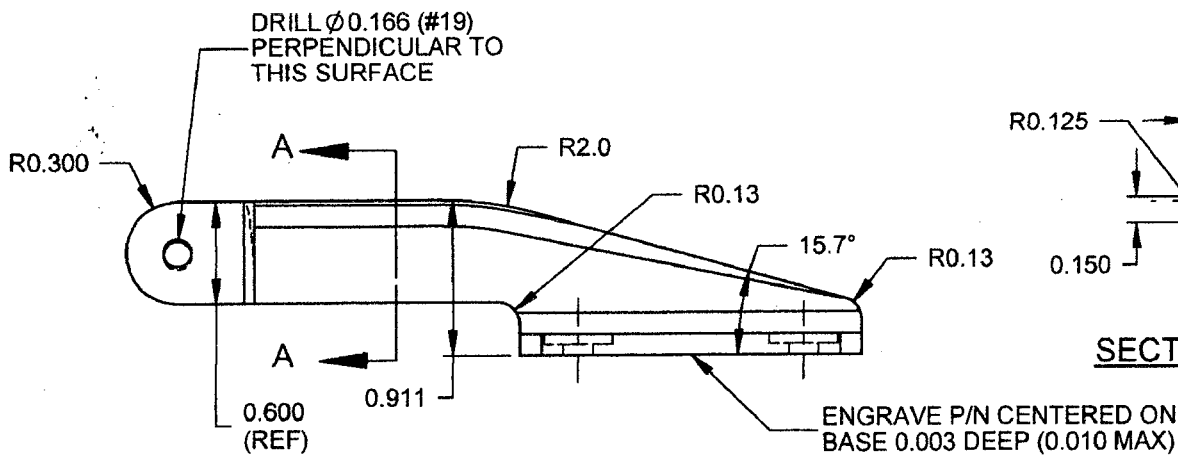
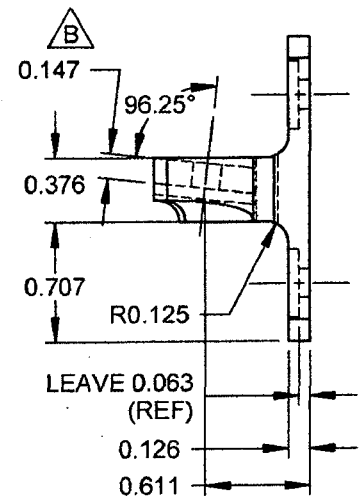
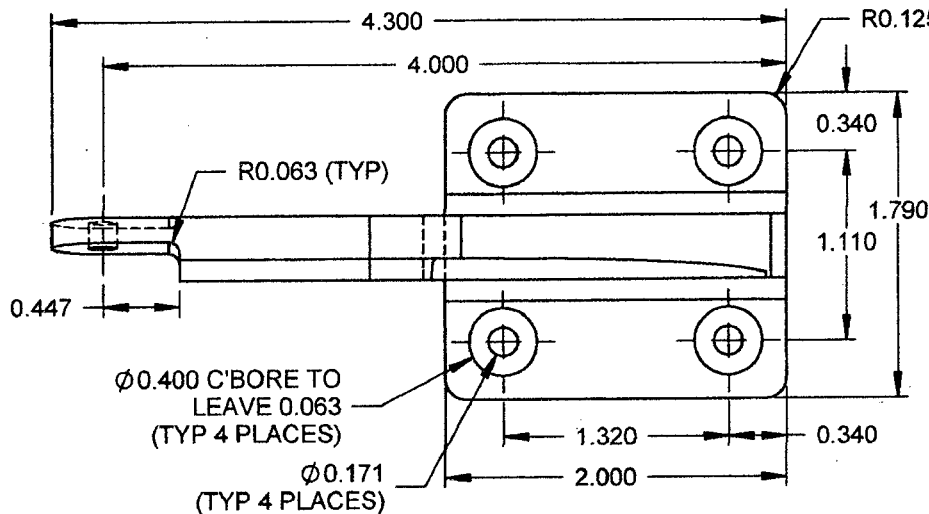
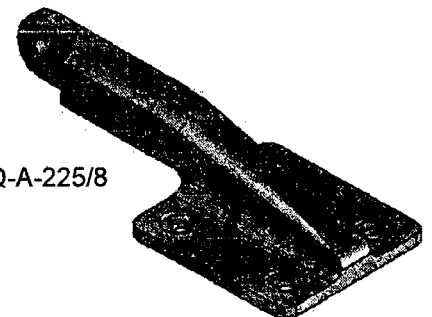
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.303	✓		VERN	GA-01
4.000	+/-0.010	4.001	✓		"	"
0.340	+/-0.010	0.341	✓		"	"
1.110	+/-0.005	1.110	✓		"	"
1.790	+/-0.010	1.791	✓		"	"
1.320	+/-0.005	1.320	✓		"	"
2.000	+/-0.010	2.001	✓		"	"
0.340	+/-0.010	0.340	✓		"	"
0.447	+/-0.010	0.447	✓		"	"
Ø0.171	+0.005/-0.000	Ø0.173	✓		"	"
0.147	+/-0.010	0.145	✓		"	"
0.376	+/-0.010	0.377	✓		"	"
0.126	+/-0.010	0.121	✓		"	"
0.063	+/-0.010	0.059	✓		"	"
Ø0.166	+0.005/-0.000	Ø0.167	✓		"	"
0.911	+/-0.010	0.908	✓		"	"
0.600	+/-0.010	0.597	✓		"	"
0.125	+/-0.010	0.127	✓		"	"
0.150	+/-0.010	0.150	✓		"	"

Measured by: H.A	Audited by: 	Prototype Approval:	N/A
Date: 10/09/13	Date: 10/09/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

DART

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06-10-13*w/o 61525***SECTION A-A****D2857-1 HINGE BRACKET**
D2857-2 OPPOSITE**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	ALS4-1032-130 / Insert	Main Warehouse ST282	61220	QUIR01		197.0000		159.0000		
		Main Warehouse ST282	61586	QUIR01	8/11/10	-16.0000	114407	-16.0000		-\$2.08
		Main Warehouse ST282	53062	LAVO01	9/03/10	-16.0000	114407	-16.0000		-\$2.08
		Main Warehouse ST282	61888	DESJ02	9/13/10	-10.0000	114407	-10.0000		-\$1.30
		Main Warehouse ST282			9/14/10	-17.0000	114407	-17.0000		-\$2.21
								-1,648.0000		-\$214.24
	M6061T6B2.000X01.250 / 6061-T6 Bar 2.00 x 1.25	Main Warehouse MAT	57925	DCUSER		40.0000		40.0000		
		Main Warehouse MAT	57924	FAUT01	5/18/10	-10.9200	114407	-10.9200		-\$83.96
		Main Warehouse MAT	59612	FAUT01	6/10/10	-10.4000	114407	-10.4000		-\$79.96
		Main Warehouse MAT	61525	DCUSER	6/14/10	-0.3333	114407	-0.3333		-\$2.56
		Main Warehouse MAT	61529	DCUSER	9/13/10	-0.7789	114407	-0.7789		-\$5.99
		Main Warehouse MAT	62795	DCUSER	9/13/10	-0.7789	114407	-0.7789		-\$5.99
		Main Warehouse MAT	62914	DCUSER	11/02/10	-0.6667	114407	-0.6667		-\$5.13
		Main Warehouse MAT			11/02/10	-0.6667	114407	-0.6667		-\$5.13
								-24.5445		-\$188.72

B/N
should
reze
114507